

Date: Wednesday, 3/12/2008 1:51:02 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BACK PANEL
Job Number	: 37876		
Estimate Number	: 11093		
P.O. Number	:	Part Number	: D30231
This Issue	: 3/12/2008 S.O. No. :	Drawing Number	: D3023 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 36149	Material	:
Written By	:	Due Date	: 4/11/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>10 08 03 12</u>		
Comment	: Est. 02.01.23 Revised NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 3.0216 sf(s)/Unit Total : 3.0216 sf(s)
 2024-T3 .032 sheet
 Material: 2024-T3 sheet (QQ-A-250/4) 0.032"
 Batch: 109240 HB 8-10-30

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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A flow SBT
A HB 8-10-30



Comment: LARGE FABRICATION RESOURCE 1

~~1-Trace and Cut Out Panel Using DT8821 Jig~~
 Done at water Sch

~~2-Drill Using Dt8821~~

~~3-Deburr~~ HB 8-10-30

4-Form as per dwg D3023

10/11/04

①
 SB 02/11/03 ①

3.0	QC5	INSPECT WORK TO CURRENT STEP
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~~HB 8-10-30~~ Solutor



Comment: INSPECT WORK TO CURRENT STEP

06/10/30 (X)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

M-12 08/11/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BACK PANEL

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Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

POWDER COATING

POWDER COATING



M 106442



(IX)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-h 08/11/06

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



js



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-07 (XV)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP4246

JS 08/11/06 (V)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/06 JS

Job Completion



MF 08-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

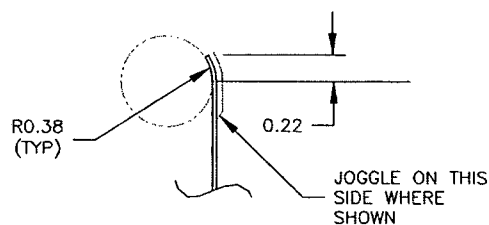
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

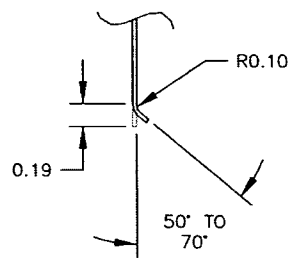
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)



SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

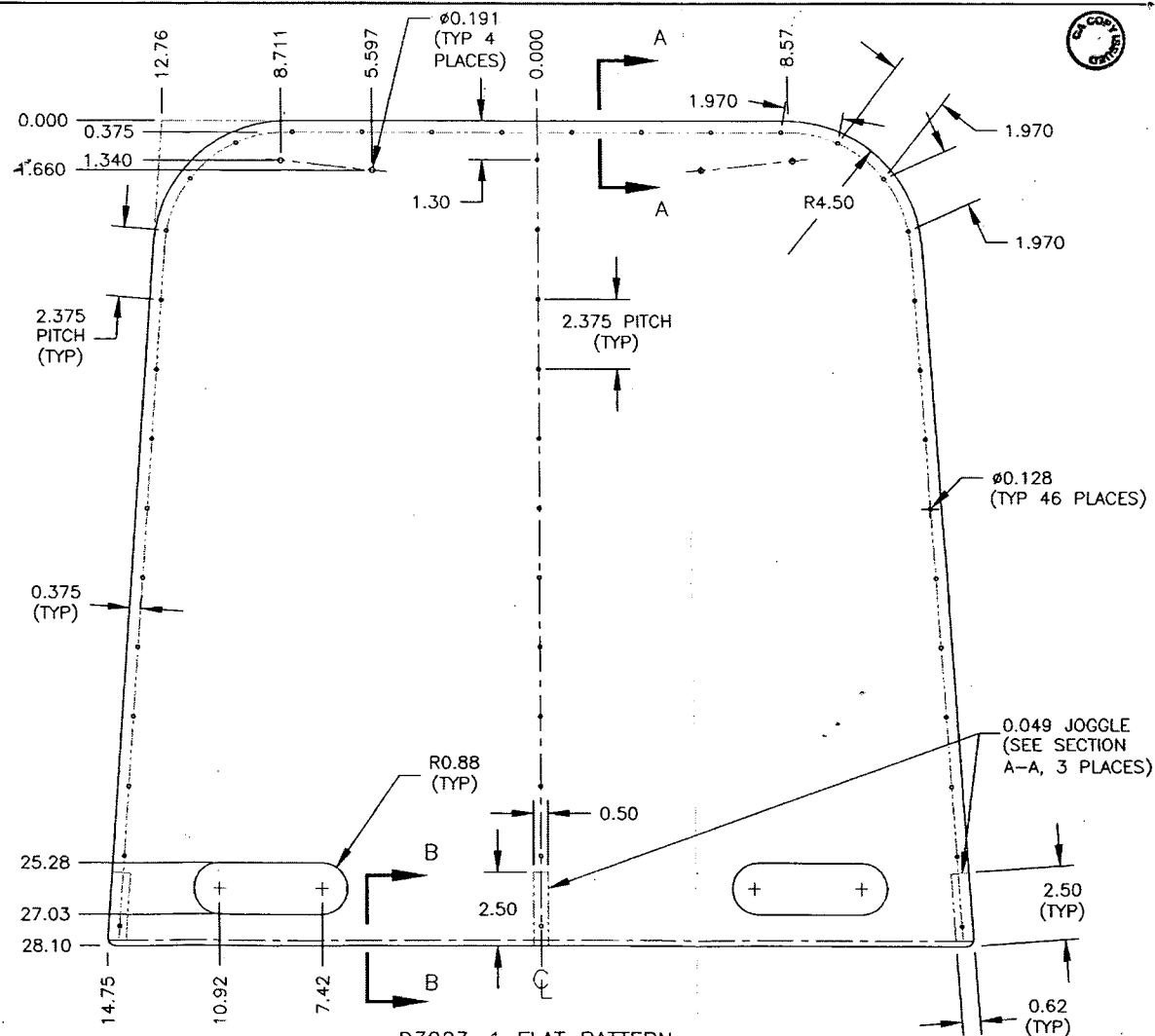
WORK ORDER NO. 37876
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SUBJECT TO AMENDMENT
WITHOUT NOTICE

22.05

R4.7

15°

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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A	01.05.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3023
DATE	TITLE	REV. A SHEET 1 OF 1 SCALE 1:4
01.05.18	- BACK PANEL	

